

Monday, May 15, 2017 1:51:48 PM

Item ID:	D4436-041	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:						
Item Name:	Aft Bracket Assembly				Stop	*NS2*
Start Date:	3/6/2017	Start Qty:	2.00	*2*	Cust Item ID:	
Required Date:	3/8/2017	Req'd Qty:	2.00	*2*	Customer:	
Reference:	SCHEDULED					

Approvals:

Process Plan:	<u>21</u> <u>9-89</u>	Date:	<u>MAY 15 2017</u>	Tooling:	_____	Date:	_____	Run	Start	*NR1*
QC:	_____	Date:	_____	SPC (Y/N):	_____	Date:	_____		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4436	A ✓								
100		0.00							
100						2	Ø	MAY 31 2017	DAS 19 9-89
Small Fab	Memo	0.51							
Small Fab	Assemble as per dwg and intall grommet								
110	QC5- Inspect part completeness to step on W/O	0.00							
110						2			DAS 38 9-89
QC	Memo	0.04							JUN 01 2017
Quality Control									
160	Identify as per dwg & Stock Location: <u>ST6K</u>	0.00							
160									
Packaging	Memo	0.02							DAS 6 9-89
Packaging						2		JUN 02 2017	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By 	
								Lead hand / Supervisor Approval Verification 	
								QC / QA Coordinator Approval 	

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Work Order ID 157663***157663***

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Item ID: D4436-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Bracket Assembly
Start Date: 3/6/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 3/8/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.20							
Quality Control									

DAS
21
9-89

JUN 02 2017



Work Order update only ☐

Work Order: _____						DISPOSITION						AGAINST DEPARTMENT/PROCESS							
Part No. _____						Rework ☐						Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐	
						Scrap ☐						Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐	
NCR No. _____						Use-as-is ☐						Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐	
Suspected Unapproved ☐						Large Fab ☐		Composite ☐		Supplier ☐									
Date :				Step #:				QTY Effective :				MRB (QS1042) Approval							
Description Work Order Deviation								Disposition								Completed By			
																Lead hand / Supervisor Approval Verification			
																QC / QA Coordinator Approval			
Root Cause				FAULT CATEGORY															
☐ Environment	☐	☐ No Re-verification	☐	☐ Pressure/Forced	☐	☐ Temperature/Cure	☐	☐ Power Loss/Surge	☐	☐ Positioned Wrong									
☐ Design	☐	☐ Operator	☐	☐ Bending	☐	☐ Set-up	☐	☐ Folio/Program	☐	☐ Outside Dimensions									
☐ Doc/Data	☐	☐ Offset/Setup	☐	☐ Centre Not Concentric	☐	☐ BOM/Route	☐	☐ Grain	☐	☐ Over/Under tolerance									
☐ Equip/Tooling	☐	☐ Supplier	☐	☐ Cracks	☐	☐ Broken/Damage/Defect	☐	☐ Weld	☐	☐ Part Incorrect									
☐ Handling/Pre	☐	☐ Training	☐	☐ Crimp/Kink/Ripple/Wave	☐	☐ Inspection Incomplete/Unqualified	☐	☐ Wrong Stock Pulled	☐	☐ Part Lost/Missing									
☐ Material	☐	☐ Use for Testing	☐	☐ Cuffs	☐	☐ Contamination	☐	☐ Out of Sequence	☐	☐ Part Moved									
☐ Internal Transport	☐	☐ Poor Information	☐	☐ Crushing	☐	☐ Countersink	☐	☐ Off-set	☐	☐ Drawing									
☐ Tribal Knowledge	☐	☐ Rushing	☐	☐ Heat Treat	☐	☐ Cut Too Short	☐	☐ Mislabeled	☐	☐ Finish									
☐ LOA	☐	☐ Product Improvement	☐	☐ Wave/Twist in Tube	☐	☐ Instructions Incomplete/Unclear	☐	☐ Fit/Function	☐	☐ Misread									
☐ Substation	☐	☐ Process Improvement	☐	☐ Marks/Chatter	☐	☐ Drill Holes	☐	☐ Misaligned/off center	☐	☐ Turning Sequence									
☐ Past Expiry Date	☐	☐ Manufacturing Process																	
☐ Misidentified	☐	☐ Past Due	OTHER :																

Picklist Print

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Work Order ID: 157663

157663

Parent Item: D4436-041

D4436-041

Parent Item Name: Aft Bracket Assembly

Start Date: 3/6/2017

Required Date: 3/8/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.10.05 NEW ISSUE DD VERF:EC
RevB 11.12.22 per PA2 EC verified by:JLM
12.01.24 PER DWG REV.A DD VERF:EC

IPP
IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4440-1 *D4440-1* Grommet		Manufactured	No			100	Each	13.0000	1	2			DAS 19 9-89

Location

Loc Qty

Loc Code

GA

13

156932

5

157237

8

D4435-043

Manufactured No

100

Each

4.0000

1

2

**

DAS
6
9-89

MAY 29 2017

D4435-043

Mount Bracket Assembly

Location

Loc Qty

Loc Code

ST098

4

158832

4

D4436-043

Manufactured No

100

Each

2.0000

1

2

**

DAS
6
9-89

MAY 29 2017

D4436-043

Aft Outboard Bracket Assembly

Location

Loc Qty

Loc Code

ST621

2

158748

2

D4436-045

Manufactured No

100

Each

2.0000

1

2

**

DAS
6
9-89

MAY 29 2017

D4436-045

Aft Inboard Bracket Assembly

Location

Loc Qty

Loc Code

ST620

2

159362

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Work Order ID: 157663

157663

Parent Item: D4436-041

D4436-041

Parent Item Name: Aft Bracket Assembly

Start Date: 3/6/2017

Required Date: 3/8/2017

Start Qty: 2.00

Required Qty: 2.00

AN525-832R6

Purchased

No

100

Each

116.0000

4

8

AN525-832R6

Screw

**

MAY 31 2017

DAS
19
3-89

Location

Loc Qty

Loc Code

GA

33

m136787

33

ST328

83

m137371

83

8

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							